

# Work Order ID 82955

**\*82955\***

Page 1

Wednesday, April 11, 2012 3:08:15 PM

Item ID: D350-636-012

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 4/11/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 4/26/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: 

Date: 12-04-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr	Revision Nbr
D2750	F
D3492	C

*X SP*

100

0.00

**\*100\***

DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

*Set*

*1*  
*for MCT 12-6-22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 82955****\*82955\***

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Required Date: 4/26/2012 Req'd Qty: 1.00

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

**\*110\***

Skidtubes

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent ✓

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside  
AFT end per dwg D2750 ✓3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",  
deburr. ✓4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade  
fitting ✓

5- Drill only two fwd step holes using DT9616. Ensure proper positioning. ✓

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill  
Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K) ✓7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ✓  
\*\*\*SECOND SIDE\*\*\*8-Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting  
location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up  
holes for ground handling and detail L to 0.500" (8 holes per side) ✓9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to  
0.297". ✓

10-Open up holes of Detail A to 0.297" (total of 2 holes per side) ✓

JTB 11-04-12

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**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004A/R Aluminum Rod batch: *M120854*

12-Grind welds flush as per Dwg D2750

*SAD**BE 12/04/19*  
*12-04-19*

120

QC10- Inspect visual per QSI004- ground welds

0.00

**\*120\***

QC

Memo

0.00

*S. 7/14/20*

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

*S. 7/14/20*

Quality Control

W/O:		WORK ORDER CHANGES					
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Start Date: 4/11/2012 Start Qty: 1.00 **\*1\***

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

76 12-4-23

150

QC7-Inspect Chemical Conversion Coat

0.00

**\*150\***

QC

Memo

0.00

Quality Control

1 D BE12-04-23

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Item Name: Skidtube RH

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**\*1\***

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Required Date: 4/26/2012 Req'd Qty: 1.00

**\*1\***

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

**\*160\***

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1- Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2- Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3- Open float holes to .500" (4 per Side)

4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5- Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7- Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: m121221

exp. date: 12-1-4

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod

batch: m120854

9- At section AP-AP drill out x-bolt spacer to 0.404"

10- Grind welds flush as per Dwg D2750

11- Spot face ground handling holes section (total of 4 places per side) as per

1 Ø CF 12-4-23

CF 12-4-25

30812-04-26

SAD/C 12-5-1

**Dart Aerospace Ltd**

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

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Item Name: Skidtube RH

Start Date: 4/11/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 4/26/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

**\*170\***

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 82955****\*82955\***

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 4/11/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 4/26/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

Pressure Wash per QSI005 4.3

0.00

**\*190\***

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

NG 12-5-2

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*200\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:20  
320 °F  
3:50

210

QC3- Inspect Part Finish

0.00

**\*210\***

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

IX ✓ M-F  
12/5/02IR+1 q 11/10/05W121134

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 82955****\*82955\***

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Revision ID:

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Item Name: Skidtube RH

Start Date: 4/11/2012 Start Qty: 1.00

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Run Start **\*NR1\***

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Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

**\*230\***

HandFinish

Hand Finishing

HandFinishing

Memo

0.00

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Spray inside of tube with "LPS-3"  
batch: NIA4-Install blade fitting D3488-042, wearshoes and ground handling hardware as  
per dwg D2750  
SIKA FLEX 241  
BATCH: 11121221  
EXP DATE: 131015-assemble o'ring to plug as per dwg D3492 and apply o'ring lube  
A/R 55-o'ring lube batch: 111103486-Coat all exposed fasteners with "LPS Procyon"  
batch: 11114596IRH φ M 11/05/12Pto →

Dart Aerospace Ltd

W/O: 82955		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-012 PAR #: \_\_\_\_\_ Fault Category: Skid tube NCR: Yes No QA: [initials] Date: 12/06/03  
 Resolution: \_\_\_\_\_ Disposition: Rework QA: N/C Closed: [initials] Date: 12/06/29

NCR: 12-1538		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/06/03	# 230	Found the Durnin Assembly that D3488-041/042 Doesn't Align with skid tube. R.C. tol. on D3488-041/042 AND Hummer drilling of skid	[initials] 12-06-04	Drill out 24 x 5 Aft most Holes to max tol. on skid tube Drill out 24 x 5 holes on D3488 to max tol.	[initials] 12-6-04	[initials] 12/06/04	[initials] 12-06-04	[initials] 12/06/03
		Process	[initials] 12-06-04	touch up Align as per 052005 AND Re-assembly	[initials] 05-18	[initials] 12/06/04	[initials] 12-06-04	[initials] 12/06/03

NOTE: Date & initial all entries



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Wednesday, April 11, 2012 3:08:15 PM

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

[illegible]

**Dart Aerospace Ltd**

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Stop **\*NR2\***

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270

0.00

**\*270\***

Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

Rev F

IX  
SP  
12-6-26

280

0.00

**\*280\***

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

12/6/27  
MF  
12-06-26

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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# Picklist Print

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Work Order ID: 82955

\*82955\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:102.09.25Rearranged procedure stepsKJ  
 IPP Rev:J 06-03-29 As per Rev D EC  
 IPP Rev:K 06-07-13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O  
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as  
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-3-BENT

Manufactured No

110

Each

24.0000

1

\*D2600-3-BENT\*

Extrusion Bent

B83305

\*\*

① 12-04-19

Location	Loc Qty	Loc Code
LG	24	
66875	7	
73253	1	
75021	1	
75022	1	
75023	1	
81330	4	
82347	9	

D2744

Manufactured No

110

Each

39.0000

1

\*D2744\*

Cap

\*\*

BE 12/04/19

Location	Loc Qty	Loc Code
LG002	39	
62715	1	
70881	3	
78900	35	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

5.0000

1

1

\*D2739\*

350 I Beam

\*\*

①

CF 12.4.25

B83449

Location

Loc Qty

Loc Code

LG

5

72155

1

81508

1

82123

3

D2743

Manufactured No

160

Each

290.0000

8

8

\*D2743\*

Crossbolt Spacer

\*\*

★

8

BE 12-04-25

Location

Loc Qty

Loc Code

LG

-3

81965

207

LG001

293

67766

4

68251

3

73403

64

74445

1

78603

2

79517

9

D3490-3

Manufactured No

160

Each

58.0000

4

4

\*D3490-3\*

Cross Bolt Spacer

\*\*

BE 12-04-26

Location

Loc Qty

Loc Code

LG

56

82016

56

LG001

2

78800

2

4

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

**\*82955\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

92.0000

4

4

**\*D3490-1\***

Cross Bolt Spacer

\*\*

SE 12-04-26

Location

Loc Qty

Loc Code

LG

83

81976

83

LG001

9

62450

2

74875

4

77042

3

4

D3631-1

Manufactured No

230

Each

227.0000

8

8

**\*D3631-1\***

Washer

\*\*

yl 12105103

Location

Loc Qty

Loc Code

FG

100

81874

100

ST072

127

68062

2

75548

125

B81074

x8

D3791-1

Manufactured No

230

Each

25.0000

1

1

**\*D3791-1\***

Wearplate

\*\*

yl 12105103

Location

Loc Qty

Loc Code

FP002

25

62239

2

78897

7

82168

16

B83392

x1

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

**\*82955\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

30.0000

1

1

**\*D3793-3\***

Wearshoe

\*\*

Y1 12/05/03

Location

Loc Qty

Loc Code

FP001

23

80434

11

82166

12

FP002

7

78935

7

MS21043-6

Purchased No

230

Each

765.0000

4

4

**\*MS21043-6\***

NUT

\*\*

Y1 12/05/03

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

745

112314

39

117887

6

118384

200

120308

500

D3794-1

Manufactured No

230

Each

39.0000

1

1

**\*D3794-1\***

Gasket

\*\*

Y1 12/05/03

Location

Loc Qty

Loc Code

FP

23

82167

23

FP002

16

75042

4

80435

12

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

**\*82955\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

259.0000

8

8

**\*NAS1611-010\***

O-RING

\*\*

41 12/03/03

Location

Loc Qty

Loc Code

FP

50

11121415

28

110915

0

120770

50

FP001

209

110915

14

117460

8

118077

1

118612

3

119438

47

120986

50

121166

36

121259

50

D2741

Manufactured

No

250

Each

61.0000

1

1

**\*D2741\***

Blade, 350 Skidtube

\*\*

SP 12-6-22

Location

Loc Qty

Loc Code

ST

-10

ST466

71

71856

1

76984

20

79516

40

1x

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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# Picklist Print

Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

\*82955\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

190.0000

4

4

**\*NAS1515H3I \***

WASHER

\*\*

yl 12/05/03

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

150

118686

3

119438

1

120360

96

121243

50

X4

NAS1611-013

Purchased

No

230

Each

218.0000

8

8

**\*NAS1611-013\***

O-RING

\*\*

yl 12/05/03

Location

Loc Qty

Loc Code

FP001

218

116582

5

117291

2

117887

53

119623

36

120910

4

121166

68

121259

50

NA121584

yg

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 82955

\*82955\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 501.0000 4 4

\*AN3C6A\*

BOLT

\*\*

HL 12/05/03

Location	Loc Qty	Loc Code
FP001	1	
111982	1	
ST351	500	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	21	
120423	11	
120693	400	

XL

NAS1149C0832R Purchased No 230 Each 293.0000 1 1

\*NAS1149C0832R\*

WASHER

\*\*

HL 12/05/03

Location	Loc Qty	Loc Code
ST297	293	
114915	293	

XL

D3536-25 Manufactured No 230 Each 22.0000 1 1

\*D3536-25\*

Gasket

\*\*

HL 12/05/03

Location	Loc Qty	Loc Code
FP	14	
81342	14	
FP002	8	
78902	8	

1383391

Y1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 82955

**\*82955\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-3 Manufactured No

230

Each

23.0000

1

1

**\*D3794-3\***

Gasket

\*\*

HL 12/05/03

Location

Loc Qty

Loc Code

FP002

23

B83396

Y1

74530

2

80436

21

AN3C5A Purchased No

230

Each

1,592.000

34

34

**\*AN3C5A\***

Bolt

\*\*

HL 12/05/03

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1585

X1121060

X3

116419

28

117343

13

117764

7

117872

2

119749

23

120423

512

1210168

500

121255

500

D3537-1 Manufactured No

230

Each

69.0000

3

3

**\*D3537-1\***

Wearpad

\*\*

HL 12/05/03

Location

Loc Qty

Loc Code

FG

10

B81959

X3

79833

10

FP002

59

69817

5

80337

5

81361

49

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

# Picklist Print

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Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

**\*82955\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

39.0000

1

1

**\*D3535-25\***

Wearshoe

\*\*

21 12/05/03

Location

Loc Qty

Loc Code

FP001

39

62233

1

80331

10

81357

11

82156

17

X)

D3492-3

Manufactured No

230

Each

69.0000

8

8

**\*D3492-3\***

Plug

\*\*

B83099 (x8) 21 12/05/02

Location

Loc Qty

Loc Code

FP-A

69

81967

69

AN960C10L

NAS1149C0332  
R

Purchased No

230

Each

0.0000

38

38

**\*AN960C10L \*** ✓

washer

11121509 (x38) 21 12/05/02

D3488-042

Manufactured No

230

Each

15.0000

1

1

**\*D3488-042\***

Blade Fitting Assembly, RH

\*\*

21 12/05/03

Location

Loc Qty

Loc Code

FP002

15

62003

1

75068

8

77015

6

B82258

X)

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

**\*82955\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

2,433.000

38

38

**\*ALS4-1032-225\***

Insert

\*\*

*ll 12/05/03*

Location

Loc Qty

Loc Code

ST281

2410

108696

146

110768

62

118386

55

118966

68

120671

79

121269

2000

ST282

23

120410

10

120451

13

*x38*

D3492-1

Manufactured

No

230

Each

30.0000

8

8

**\*D3492-1\***

Plug

\*\*

*ll 12/05/03*

Location

Loc Qty

Loc Code

FP002

30

69531

8

74444

2

76235

4

77037

16

*B83098*

*x8*

D3793-1

Manufactured

No

230

Each

26.0000

1

1

**\*D3793-1\***

Wearshoe

\*\*

*ll 12/05/03*

Location

Loc Qty

Loc Code

FP001

26

78901

10

82171

16

*x1*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



# Picklist Print

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Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

**\*82955\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

104.0000

1

1

**\*AN8C35A\***

BOLT

\*\*

xl n105103

Location

Loc Qty

Loc Code

FP002

103

115960

1

117834

7

118286

45

121275

50

ST346

1

114442

0

115188

0

115960

1

MS21083C8

Purchased

No

230

Each

105.0000

1

1

**\*MS21083C8\***

NUT

\*\*

xl n105103

Location

Loc Qty

Loc Code

304

50

121185

50

FP002

1

115884

1

ST303

5

115884

0

118077

1

119309

2

119638

2

ST304

49

120142

7

120731

17

121011

25

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

**\*82955\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

48.0000

8

8

**\*D2745\***

Bushing

\*\*

sl 12/05/03

Location

Loc Qty

Loc Code

FP

46

79518

46

FP001

2

B81964

x8

69529

1

76142

1

AN6C44A

Purchased No

230

Each

170.0000

4

4

**\*AN6C44A\***

BOLT

\*\*

sl 12/05/03

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

168

120143

25

120465

23

121013

20

121167

100

X4

D3532-1

Manufactured No

250

Each

51.0000

2

2

**\*D3532-1\***

Spacer

\*\*

SP 12-6-22-

Location

Loc Qty

Loc Code

ST053

51

78839

27

82041

24

2x

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

**\*82955\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

105.0000

2

2

**\*MS21083C8\***

NUT

\*\*

M12/349 2x  
SP

Location

Loc Qty

Loc Code

304

50

121185

50

FP002

1

115884

1

ST303

5

115884

0

118077

1

119309

2

119638

2

ST304

49

120142

7

120731

17

121011

25

NAS1149D0863J

Purchased

No

250

Each

211.0000

2

2

**\*NAS1149D0863.1\***

WASHER

\*\*

SP 12-6-22

Location

Loc Qty

Loc Code

ST298

211

118078

36

119307

75

120308

100

2x

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

**\*82955\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

87.0000

2

2

**\*D3493-1\***

Washer

\*\*

*SP*

Location

Loc Qty

Loc Code

ST050

87

70697

2

77573

4

78835

40

82023

41

*2x*

AN8C21A

Purchased

No

250

Each

121.0000

2

2

**\*AN8C21A\***

BOLT

\*\*

*SP 12-6-22.*

Location

Loc Qty

Loc Code

ST343

121

118758

5

120094

26

121067

20

121167

20

121275

50

*2x*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3. BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
  - MINIMUM YIELD TENSILE STRENGTH = 35 KSI
  - MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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F	INCORPORATE DSI 9413, QTY (3) D3537-1 WAS QTY (5) (ZN C8-1). D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1). D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1). ADD D3791-1 (ZN C8-1). WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8 9, 10, 11). ADD NOTE 12 AND 13 (ZN A5-1) REASON REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES. ADD RUBBER GASKETS. CHANGE INSERTS. ADD D3631-1. REMOVE QTY (38) NAS1515H3L. REMOVE QTY (10) NAS1515H8L. REMOVE D2741. QTY (2) AN960C816. REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4, INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PORT HADLOCK, WA		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

DART AEROSPACE USA, INC.

PORT HADLOCK, WA

DRAWING NO. D2750 REV. F  
SHEET 1 OF 11  
TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS

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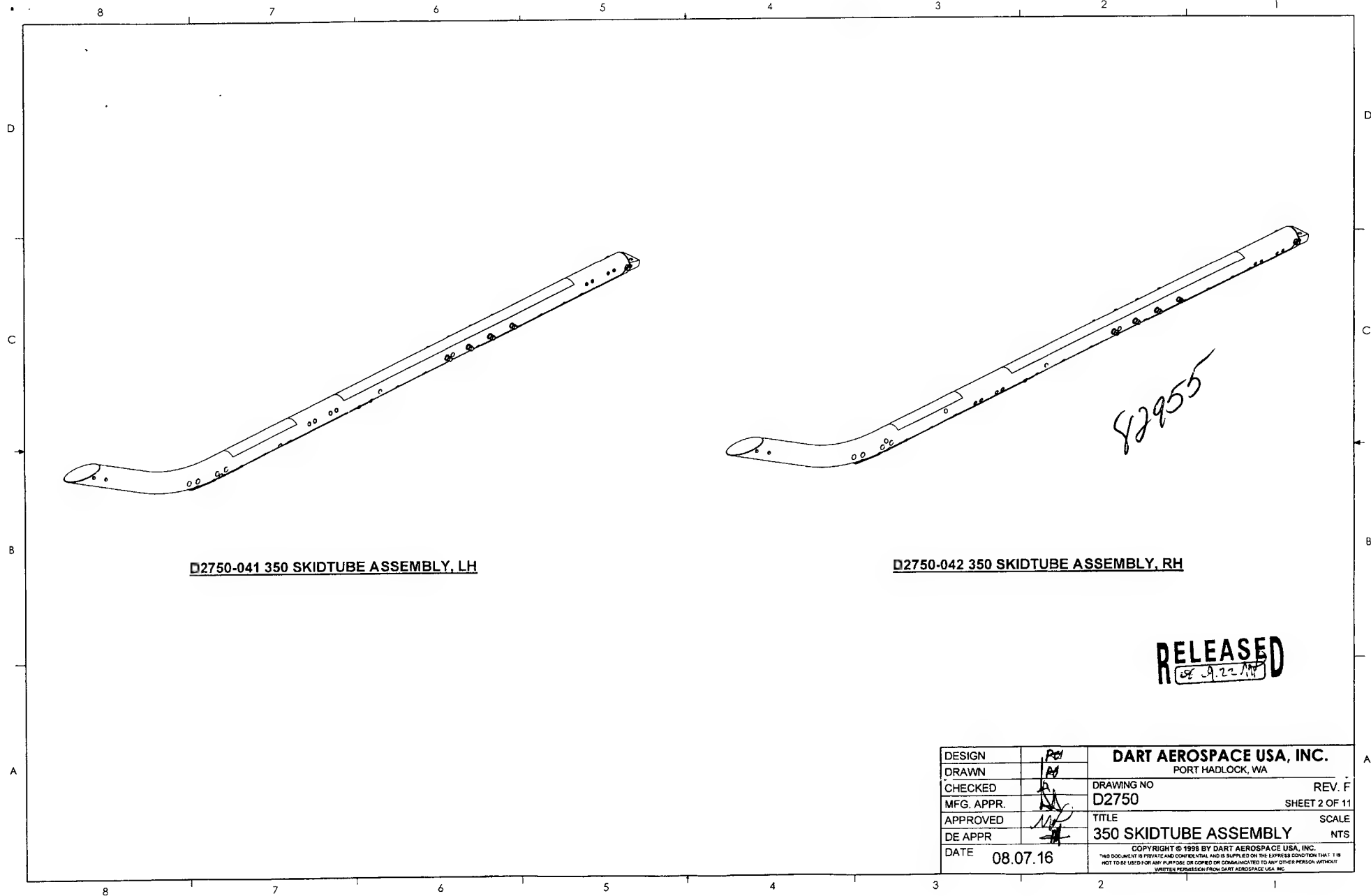
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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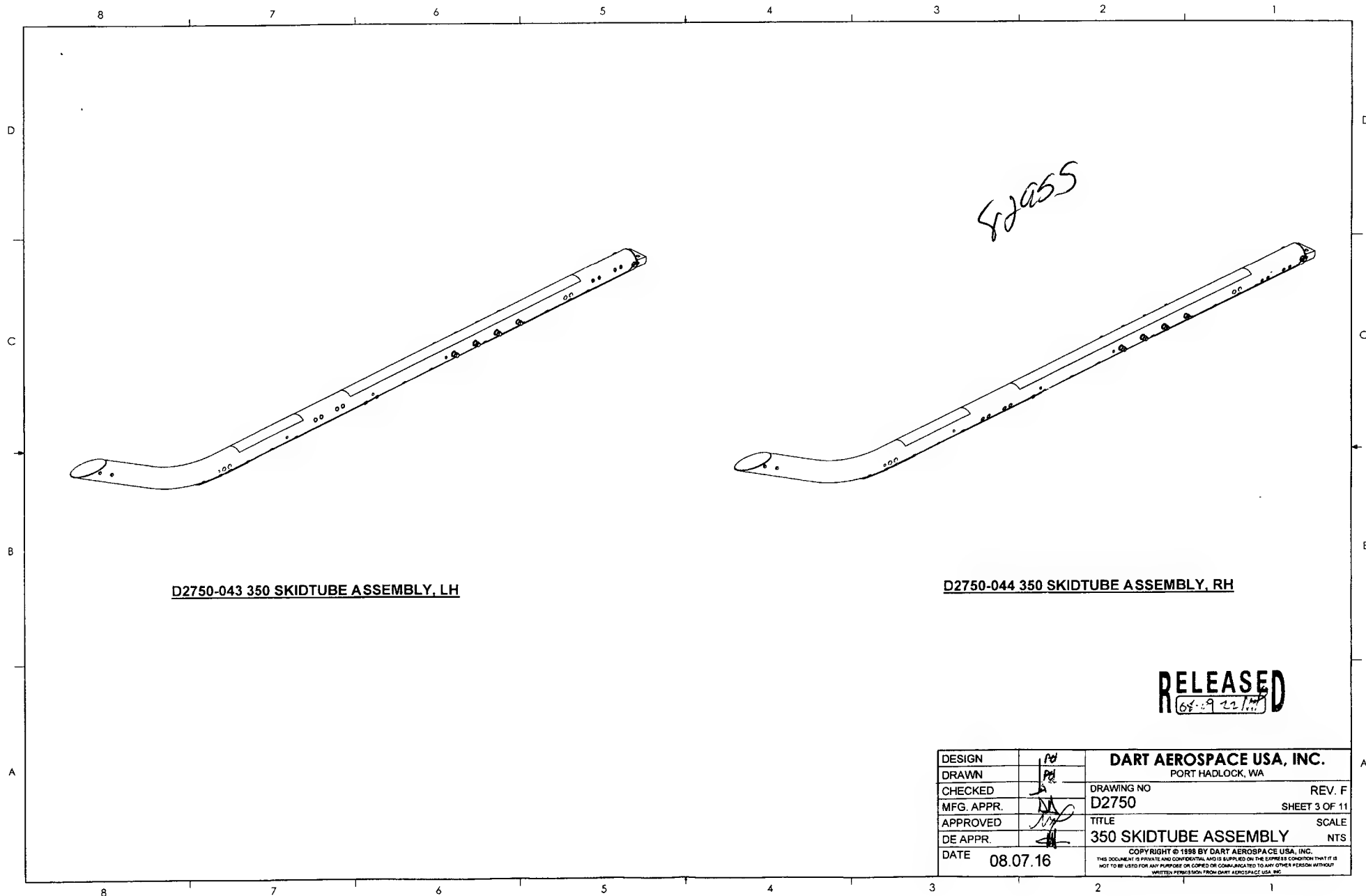
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D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

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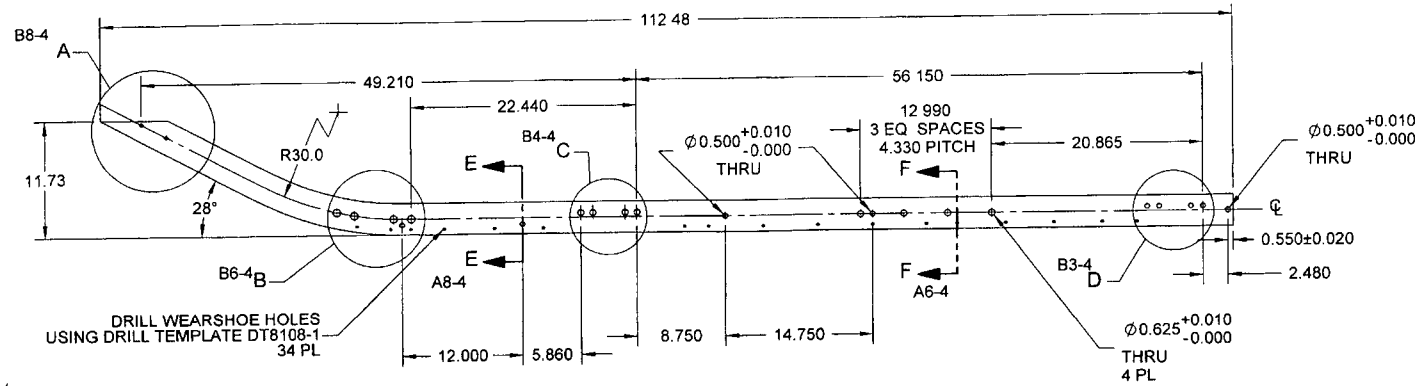
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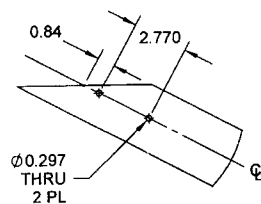
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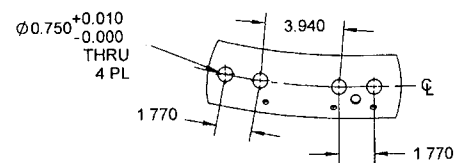


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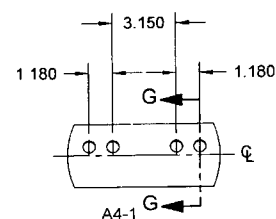
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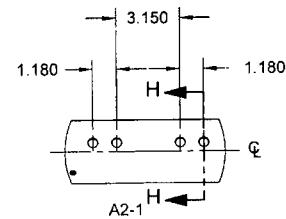
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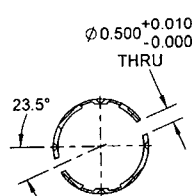
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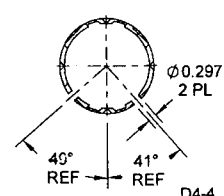
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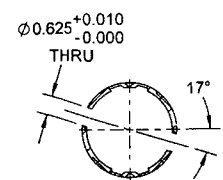
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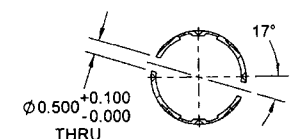
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

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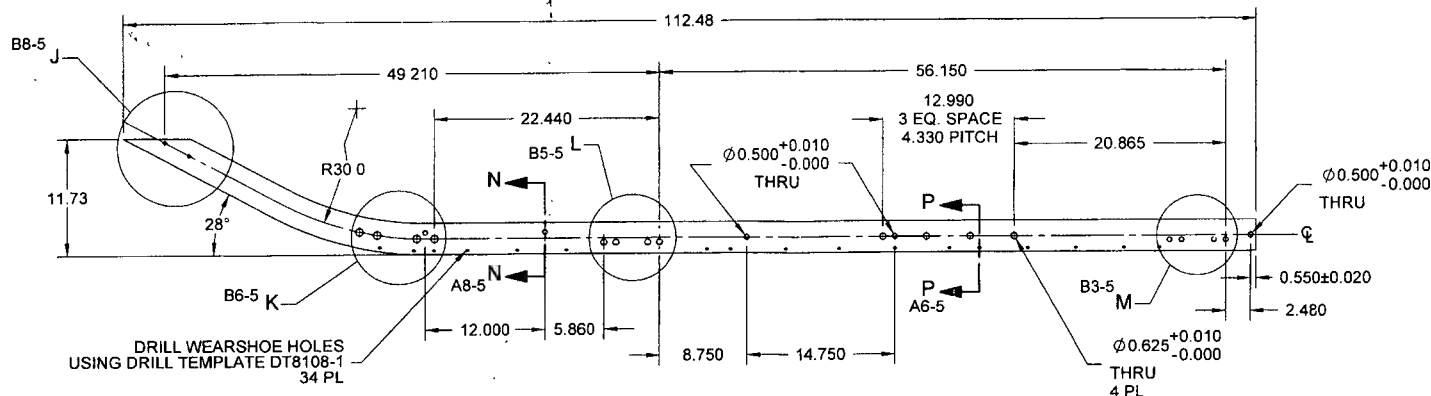
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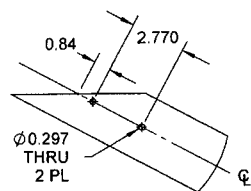
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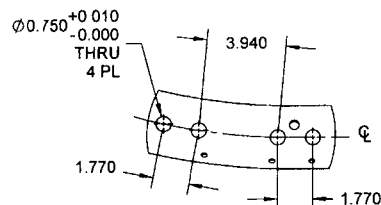




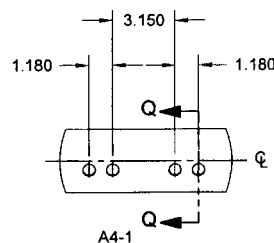
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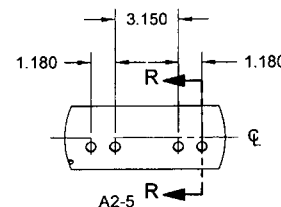
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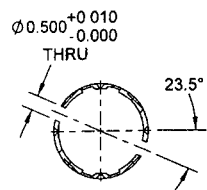
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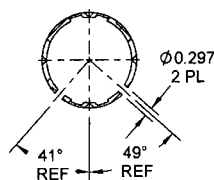
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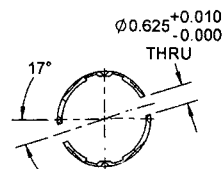
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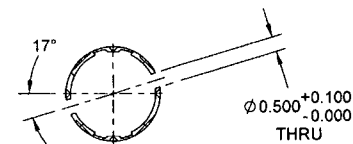
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SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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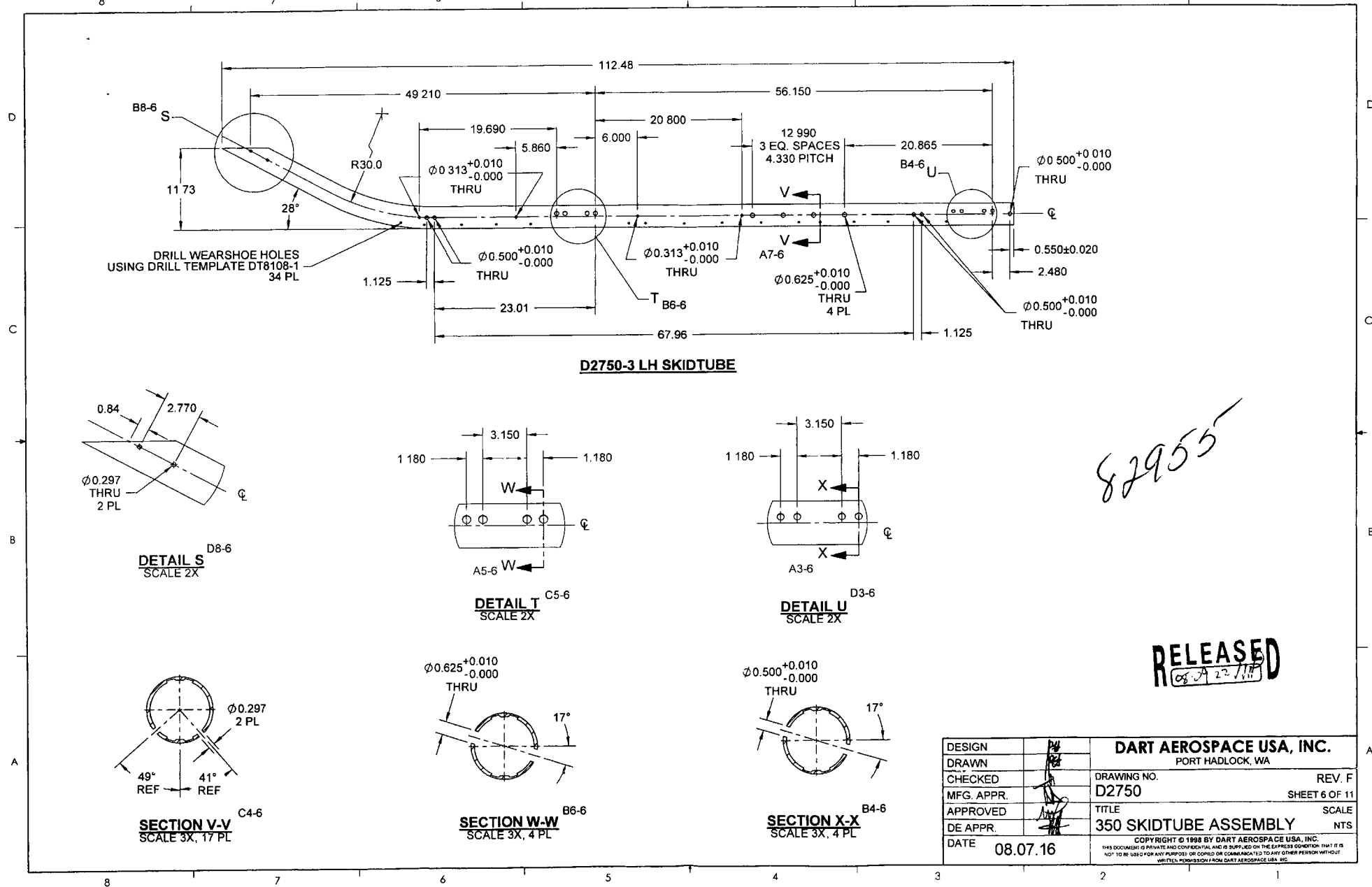
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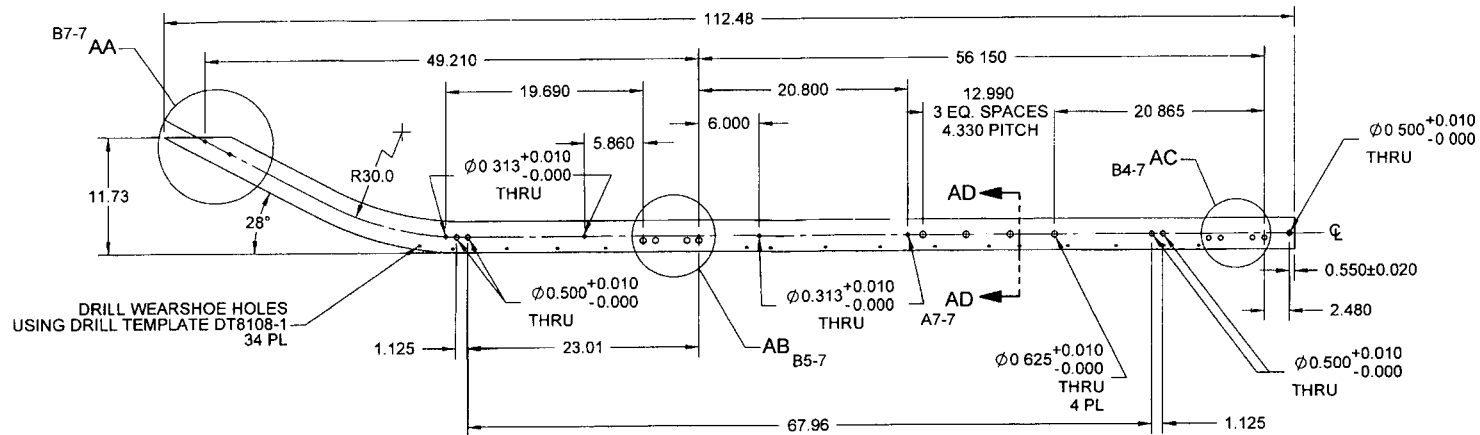
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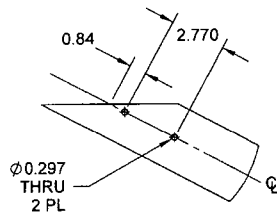
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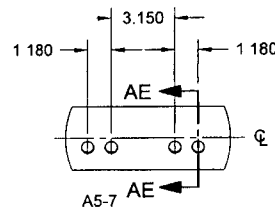
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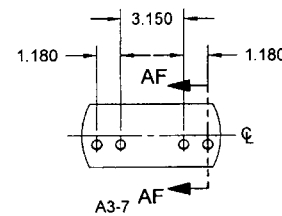
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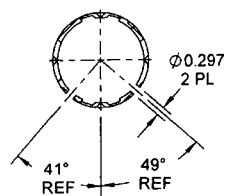
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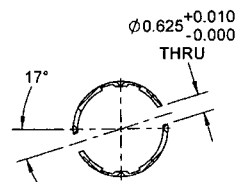
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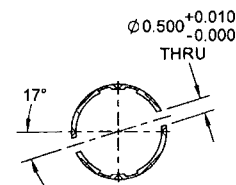
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

52955

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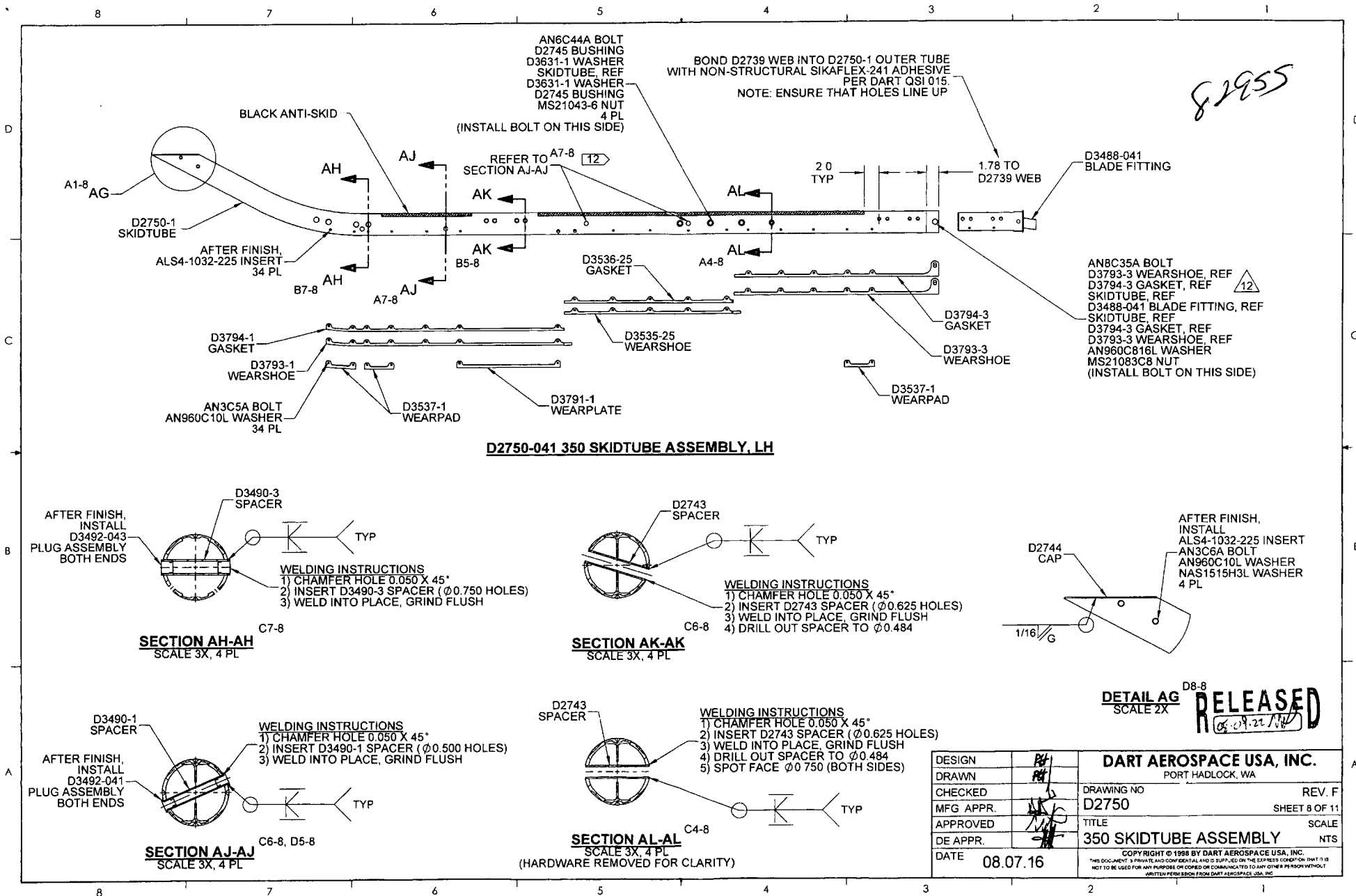
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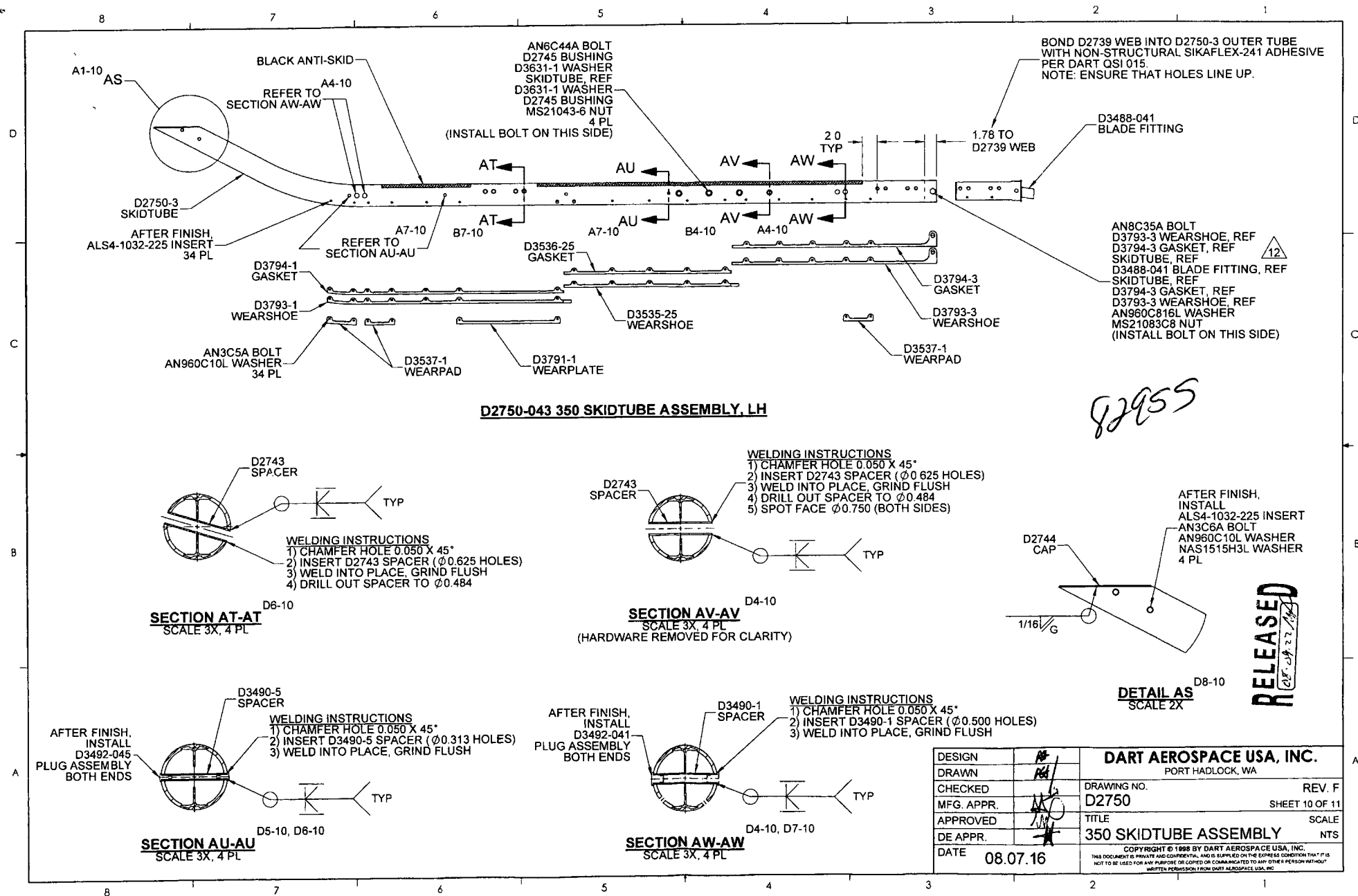
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

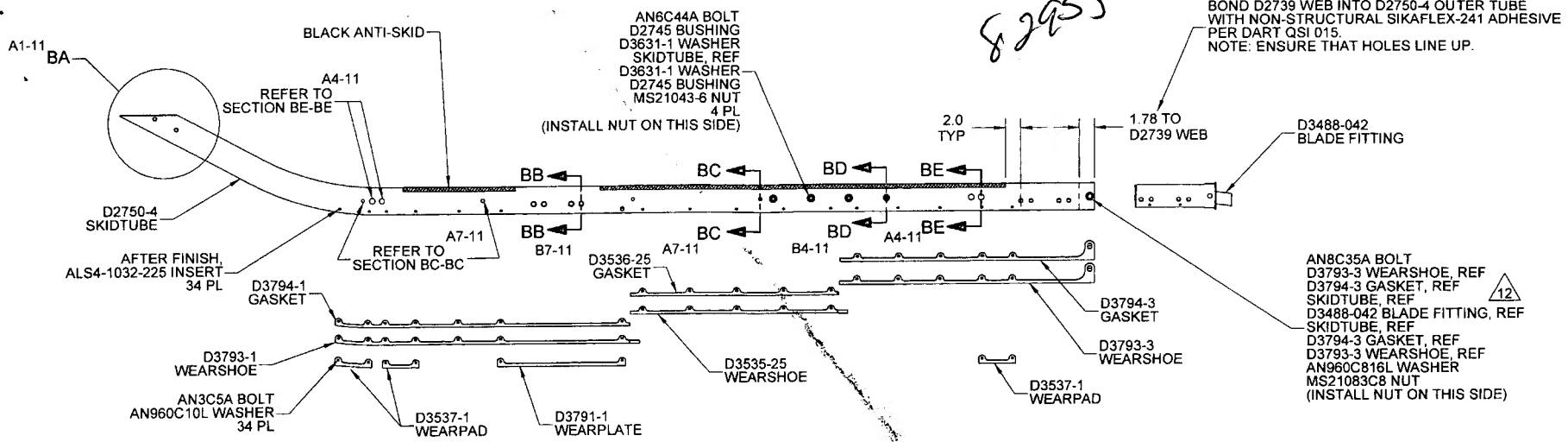
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

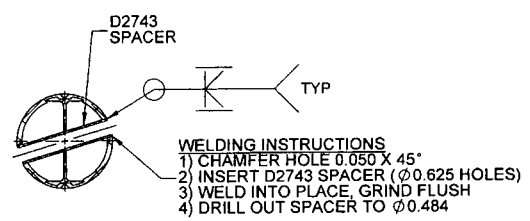
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

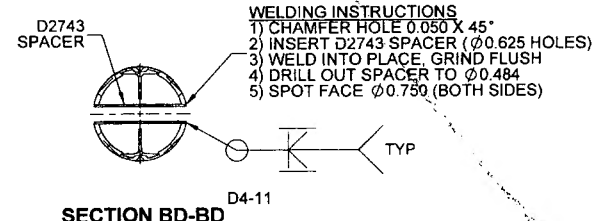
8 7 6 5 4 3 2 1



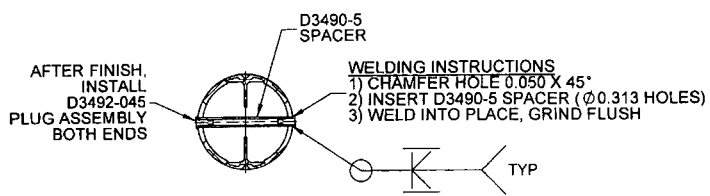
**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



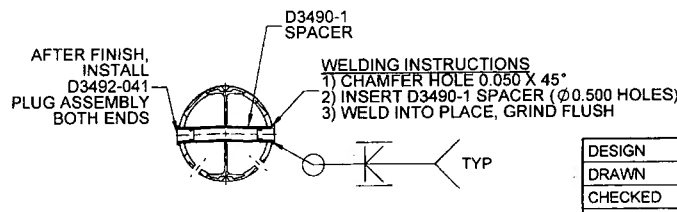
**SECTION BB-BB**  
SCALE 3X, 4 PL



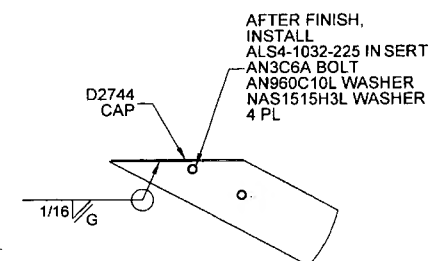
**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION BC-BC**  
SCALE 3X, 4 PL



**SECTION BE-BE**  
SCALE 3X, 4 PL



**DETAIL BA**  
SCALE 2X

**RELEASED**

DESIGN	REV. 1	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	REV. 1	PORT HADLOCK, WA	
CHECKED	REV. 1	DRAWING NO.	REV. F
MFG. APPR.	REV. 1	<b>D2750</b>	SHEET 11 OF 11
APPROVED	REV. 1	TITLE	SCALE
DE APPR.	REV. 1	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 293

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 82796  
Part number: A350-636-014  
Description: Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier David Mead Date of Test Coupon 12-05-01  
Welder Barclay Elliott Date of Test Coupon 12-05-01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

